Qtv:

C€te: User: Thursday, 07/05/2009 3:30:36 PM

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**

: 47796

P.O. Number

Prsht Rev.

First Issue

Written By

Previous Run

This Issue

: 07/05/2009

: 10822

: NC

: // : 44547

Type

: MACHINED PARTS

Part Number

Due Date

Drawing Name

: D2274

Drawing Number

: D2274 REV F : N/A

: RADIUS BLOCK

Project Number

Drawing Revision Material

: 15/05/2009

500 Um: Each

Checked & Approved By

Comment

S.O. No. :

: Est. H 00.05.18 Added inspection level 8

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

M6061T6B0750X00125

6061-T6 Bar .750 x .125





Comment: Qty.: 0.0962 f(s)/Unit

Total: 48.0900 f(s)

6061-T6 Bar .75" x .125"

Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch SHEAR

SHEAR

2.0

Comment: SHEAR

Shear blanks 9.00" long +/- 0.030"

Note: 1 blank makes 9 pieces

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1





Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2274

INSPECT PARTS AS THEY COME OFF MACHINE

09/05/

4.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



504

Comment: SECOND CHECK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
					!					
Part No	:	PAR #:	R: Yes	No DQA	۸:	Date:				

NCR:		Disposit	ion:	QA: N/C Clos	sed:	Date: _		
			WORK ORDER NON-CONFORMANCE (NCR)					
		Description of NC		Corrective Action Section	В	Verification	Approval Chief Eng	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C		Approval QC Inspector
						·		
i								

Date: Thursday, 07/05/2009 3:30:36 PM User: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: RADIUS BLOCK Job Number: 47796 Part Number: D2274 Job Number: Seq. #: Description: **Machine Or Operation:** 6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL UM FAB RESOURCE 1 Tumble Deburr any rough edges after tumbling 7.0 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 9.0 PACKAGING 1 **Comment: PACKAGING RESOURCE #1** Identify and Stock Location: 10.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL !! PECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	ES			
DATE	STEP	PRO	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		PAR #:	Fault Categ	ory:	_ NCR: Yes 1	No DQA:	Date: _	
		esolution:	Disposition	:	_ QA: N/C Clo	sed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCR))		
DATE	STEP	Description of NC	\	Corrective Action Section		Verification	Approval	Approval
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
								-

DART AEROSPACE LTD	Work Order: せつつ
Description: Radius Block	Part Number: D2274
Inspection Dwg: D2274 Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	\$ 0.259	~			
0.750	+/-0.010	0.753	/			
0.375	+/-0.010	0.374	1			
0.125	+/-0.010	O. 123	~			
0.750	+/-0.010	0.747				
0.063	+/-0.010	0.060	~			

Measured by:	Audited by: Onf	Prototype Approval:	N/A
Date: 09/05/10	Date: 69/65/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.10.07	New Issue	KJ/RF	1

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES								
DATE STEE			PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approva QC Inspector		
Part No	:	PAR #: _	Fault Category:	NCR:	Yes	No DQ	A:	Date: _			
	R	Resolution:	Disposition:	ΟΔ: Ν	/C CI	nsed:		Date:			

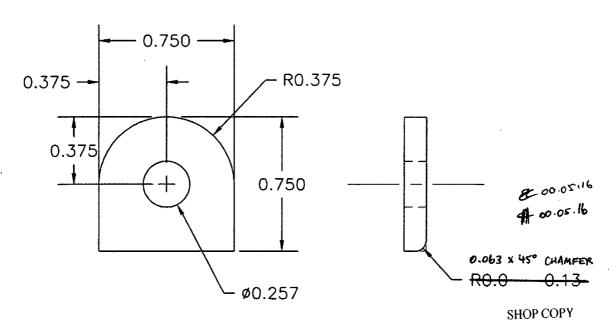
NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	Corrective Action Section B			Verification	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto		
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DESIG	KE	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	KED //	APPROYED	DRAWING NO. REV. (F
	NOV I	4	D2274 SHEET 1 OF	1
DATE		,	TITLE SCALI	E
98.0	08.11		RADIUS BLOCK 2:	1
Α		94.09.29	NEW ISSUE	
С		95.07.12	RADIUS ENDS	
D		97.03.24	ADD MATERIAL SPECIFICATION	
E		97.12.12	ADD FINISH & TOLERANCE QSI	
F		98.08.11	RO.0 - 0.13 WAS RO.063 - 0.125	

RELEASED 18/08/18 KED



RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK

OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No			Fault Category:			NCR: Yes No DQA: Date:					
NCR:			WORK ORD	ER NON-CONFORM	JANCE	(NCR)				
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verificati			n Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng	n Sign & Date		Section C		Chief Eng	QC Inspector	
							:				
	1			*	ľ						